

SPLIT

PART AEROSPACE LTD		Work Order:	22518
Description: Folding Step Weldment LH		Part Number:	D3388-041
Dwg: D3388 Rev. A		Qty:	269
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	JS	05.02.23	20
2	GA	Cut D2622-120C extrusion 85.15" long as per Dwg D3388 Batch: B21640	PD	05-03-02	10
3	GA	Deburr and bevel ends for welding	PD	05-03-02	10
4	WA	Weld arms and end caps as per Dwg D3388. Inspect for foreign objects as per QSI 024. Pick: Aluminium rod H15907 Qty Part Number Description Batch 2 D2734 End Cap B19488 2 D3387-041 Arm B22527	PD	05-03-08	10
5	GA	Grind end cap welds flush	PD	05-03-08	10
6	QC9/5	Inspect weld and work to Step 5	PD	05/03/08	10
7	FP	Chemical Conversion Coat as per QSI 005 4.1	M	05 03 12	10
8	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	M	05 03 12	10
9	FP	Wing Walk as per Dwg D3388 and QSI 005 4.4	M/SG	05/03/14	10
10	QC3	Inspect Powder Coat and Wing Walk	PD	05-06-16	954
11	ST	Identify and Stock	PD	05-06-16	954
12	AC	Cost / part: 81.26	JS	05/06/16	954
13	DC	Close W/O 81.26 Inspect Level 21	JS	05.06.17	954

Rev	Date	Change	Revised By	Approved
A	05.02.22	New Issue	KJ/JLM	

RELEASED

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR 22518 A		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Initial	Corrective Action Section B	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
05-03-08	4	When D3387-041 Arm was being welded onto D2622-1206 extrusion the ground was not fully connected to the step which resulted in a burn melting the extrusion	<i>[Signature]</i> prosser	Remove D3387-041 Arm destroy & replace extrusion	PD 05-03-10	05-03-10	<i>[Signature]</i> prosser	<i>[Signature]</i> 05-03-10

D3388-041

PAR#:

Fault Category:

Prod / Remachined Parts

DQA:

Date:

05/06/20

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\onrcB.doc

QA: N/C Closed:

Date:

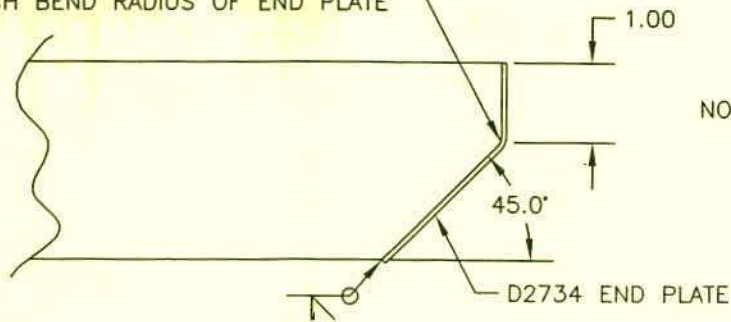
DART

RELEASED

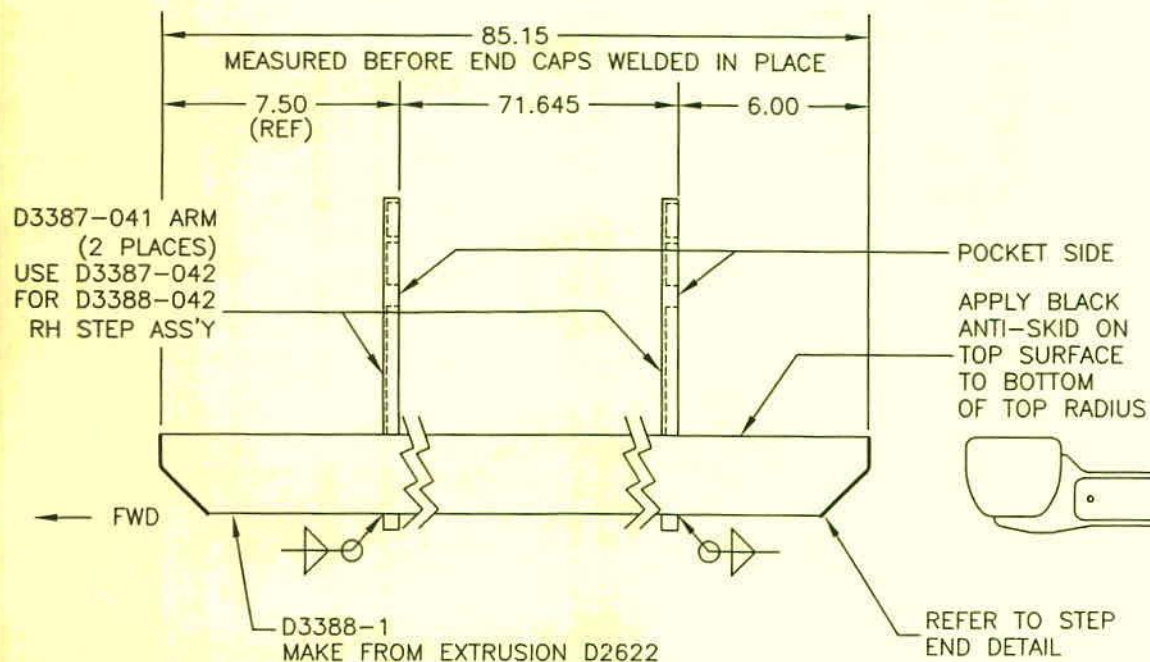
05-03-11

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE



D3388-041 LH STEP ASSEMBLY (SHOWN)
D3388-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
CP	CP	D3388
DATE	TITLE	SHEET 1 OF 1
05.01.20	STEP WELDMENT	SCALE
A	05.01.20	NTS
	NEW ISSUE	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT 1
WITH
NO. 22518

